

Date: Tuesday, 7/17/2007 2:01:05 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 33596					
Estimate Number	: 11078					
P.O. Number	: N/A		Part Number	: D2990041		
This Issue	: 7/17/2007	S.O. No.	: N/A	Drawing Number	: D2990 REV B	
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: N/A		Material	: N/A		
Written By	:		Due Date	: 8/10/2007		
Checked & Approved By	:					Qty: 7 Um: Each
Comment	: Est B 05.02.22 Revised Step 6 KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28051	Stop 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)	
	STOP	
	Pick:	
	Qty Part Number	Description Batch
	1 D2805-1	Stop <u>D30819</u>
		<i>mf 07-08-16</i>
2.0	D29901	Bracket 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : <u>8</u> .0000 Each(s)	
	Bracket	
	Pick:	
	Qty Part Number	Description Batch
	1 D2990-1	Bracket <u>B33601</u>
		<i>mf 07-08-16</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Press D2805-1 into arm as per Dwg D2990	<i>mf 07-08-16</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP 
		
	Comment: INSPECT WORK TO CURRENT STEP	<i>S 07/08/16 X8</i>
5.0	POWDER COATING	POWDER COATING 
		
	Comment: POWDER COATING	
	Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3	<i>fx 07/08/22</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASSEMBLY

Job Number: 33596

Part Number: D2990041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-08-27

7.0 AN3C16A

Bolt



16

Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M101884 -

8.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	M104936

9.0 NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch	Qty	Part Number	Description	Batch
4	NAS1515H3	Washer		4	NAS1515H3	Washer	
A/R	LPS-3	Corrosion Spray	M104929				

07/17/2007

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2990

Assemble as per Dwg D2990.

MF 07-08-27

07/17/2007

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/18/28

(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/08/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2990041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/17/28 (8)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

7/18/28

Job Completion



7/18/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

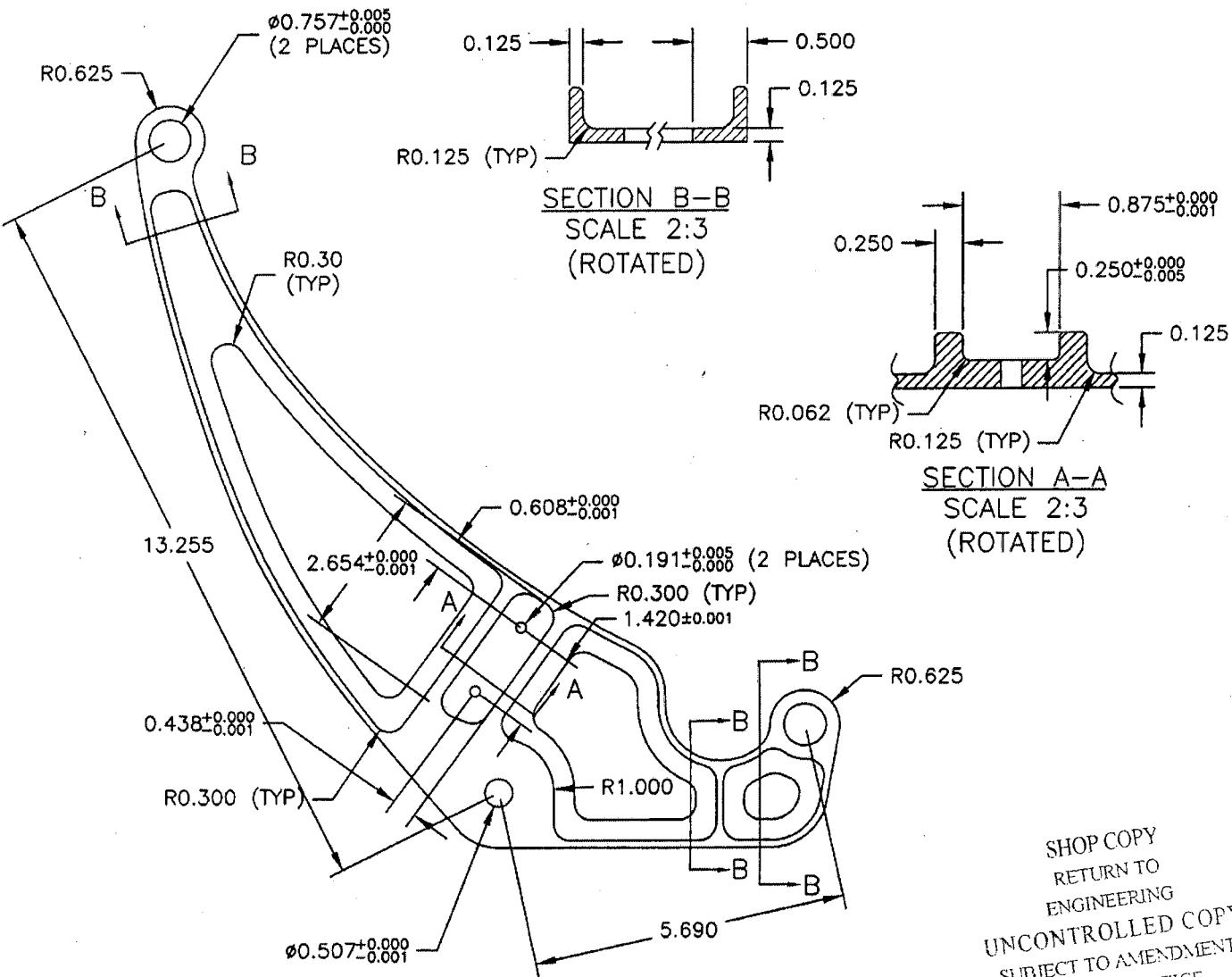
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2990	REV. B SHEET 1 OF 2
DATE 05.01.20		TITLE STA 129 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	05.01.20	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33596*

D2990-1 BRACKET (SHOWN), D2990-2 BRACKET (OPPOSITE)

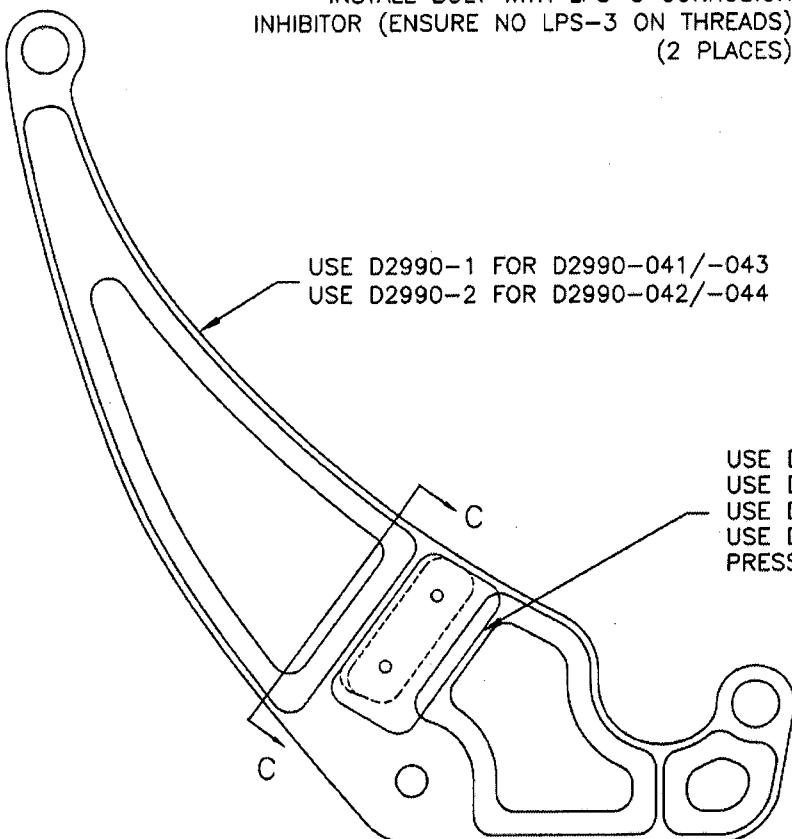
- 1) MACHINE PER DRAWING FILE "D2990.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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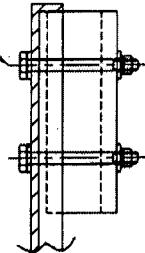
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21	TITLE STA 129 BRACKET	SCALE 1:3	

RELEASED05-03-11 *[initials]*

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2990-041
USE D2805-2 FOR D2990-042
USE D2805-3 FOR D2990-043
USE D2805-4 FOR D2990-044
PRESS INTO PLACE PRIOR TO POWDER COAT

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WITHOUT NOTICE.
WORK ORDER
NO. *33596*

D2990-041/-043 BRACKET ASS'Y (SHOWN),
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3